

Date: Thursday, 05/02/2009 9:31:54 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY
Job Number : 45508	
Estimate Number : 13667	
P.O. Number :	Part Number : D3852042
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D3852 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 44872	Material :
Written By :	Due Date : 12/02/2009 Qty: 2 U: Each
Checked & Approved By : <u>JUD 09.02.05</u>	
Comment : Est Rev:A 08-12-02 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: M44051B-4117

PD 09-02-17

2.0	D31663	Basket Hoop
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Comment: Qty.: 0.1890 Each(s)/Unit Total : 0.3780 Each(s)

Basket Hoop

batch: M44051

SAD 09-02-12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

- 1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig
- 2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852
- 3- c'sink hole as per dwg
- 4- remove identification markings
- 5- deburr

SAD 09-02-12 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09-02-13 (2)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

- 1- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: M107051

PD 09-02-17 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 9:31:54 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY

Job Number: 45508

Part Number: D3852042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind bushing weld flush as per dwg dwg D3852
3- deburr hole if necessary

PD 09-02-17 (2)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-02-17

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-18 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-02-18 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



MF 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



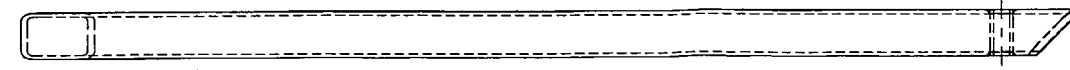
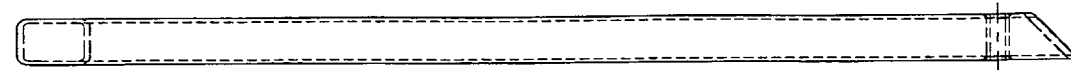
D3852-042 RIB ASSEMBLY

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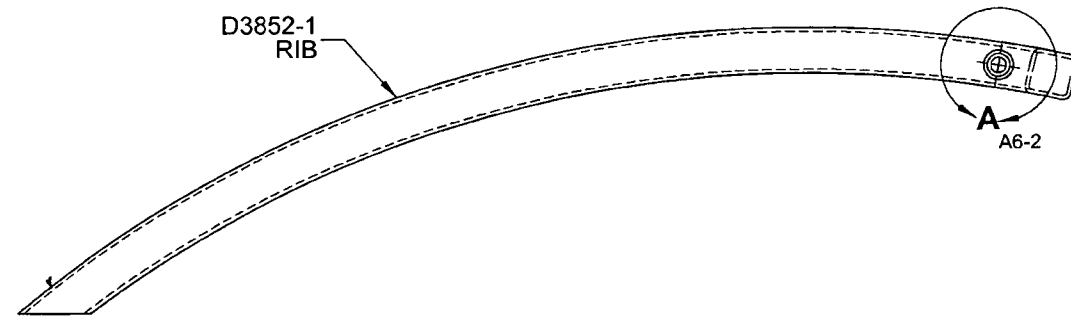
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08/11/18 MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

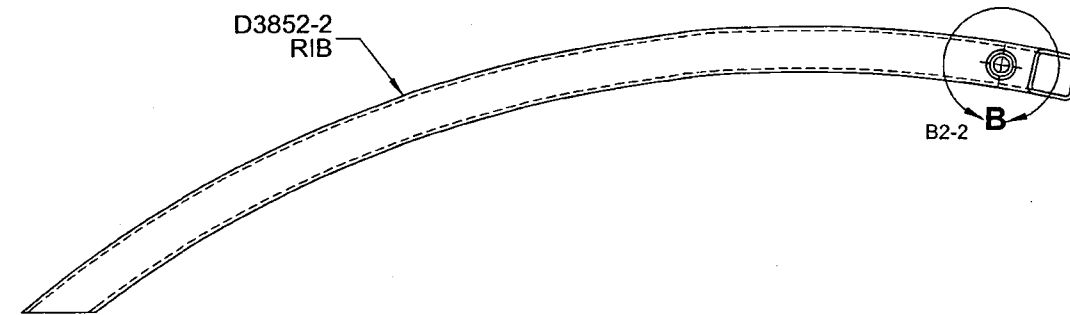
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D3852-1
RIB



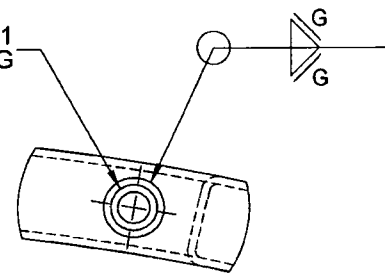
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RIB



D3852-041 RIB ASSEMBLY

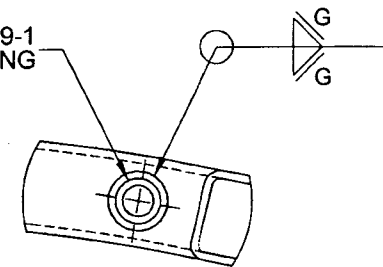
D3852-042 RIB ASSEMBLY

D3759-1
BUSHING



DETAIL A
SCALE 2X C5-2

D3759-1
BUSHING

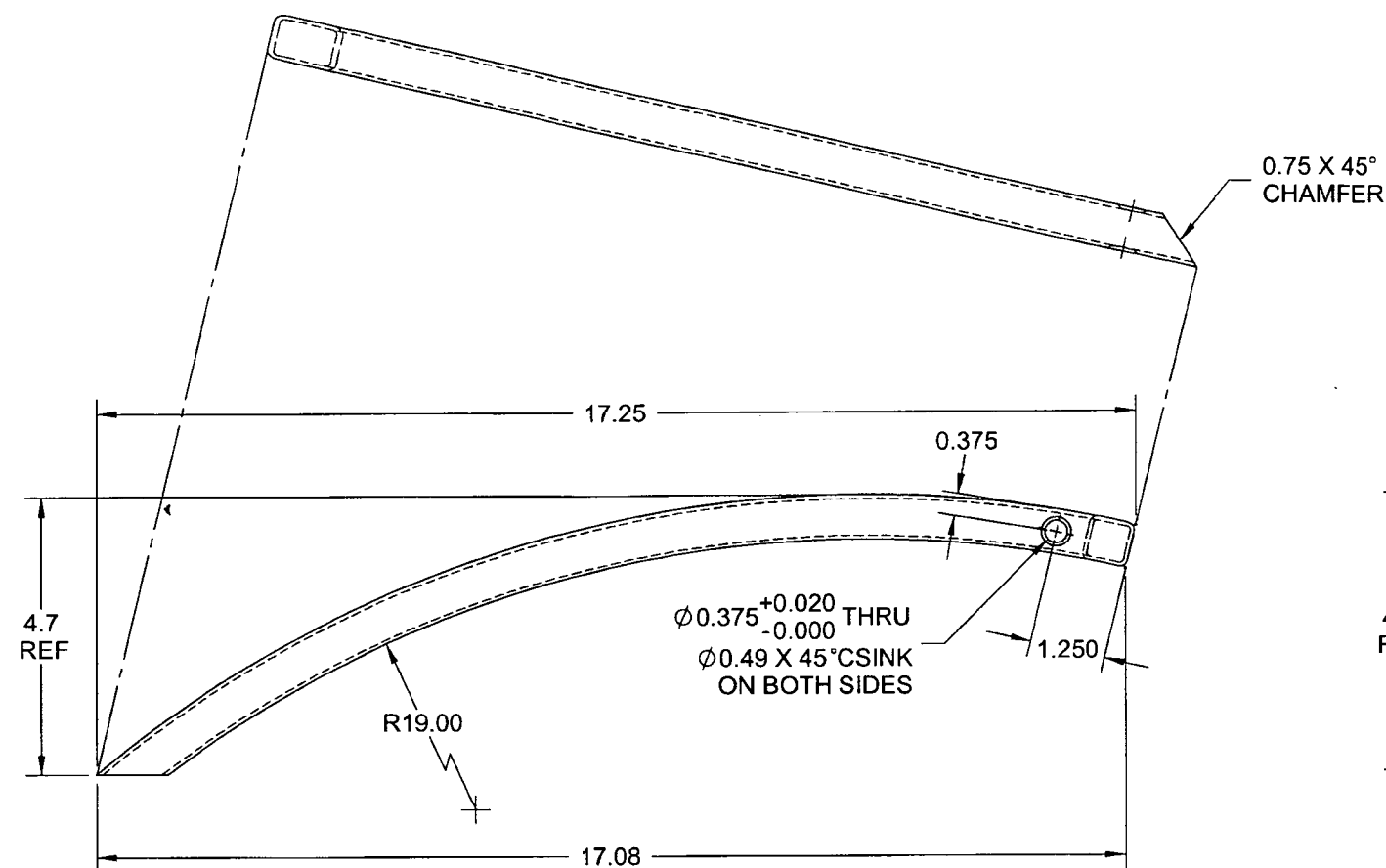


DETAIL B
SCALE 2X C2-2

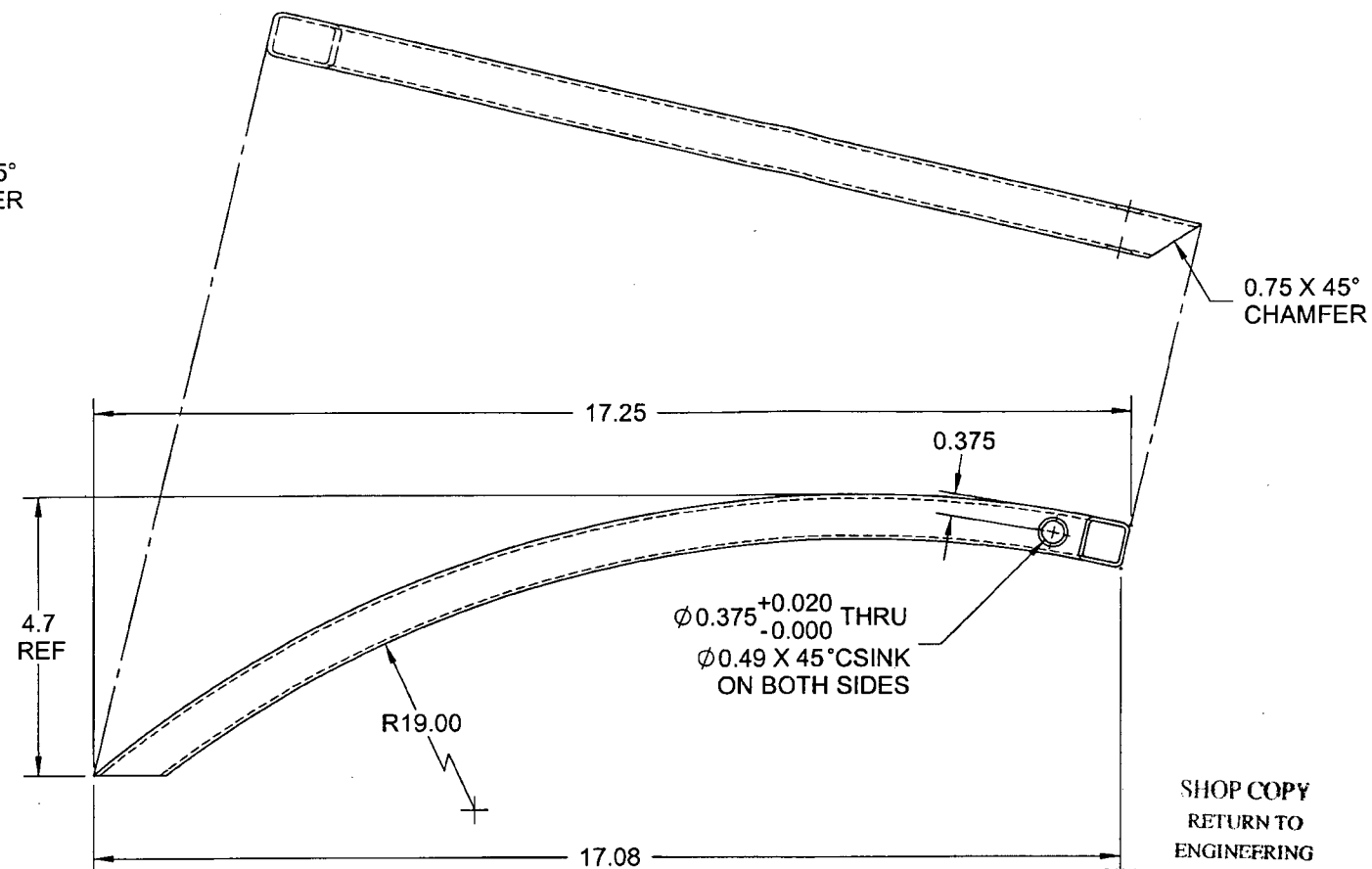
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D3852-1 RIB



D3852-2 RIB

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08/11/07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

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